

Date: Wednesday, 20/08/2008 8:47:04 AM  
 User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLEVIS
Job Number	: 41522		
Estimate Number	: 11302		
P.O. Number	:	Part Number	: D34477
This Issue	: 20/08/2008 S.O. No. :	Drawing Number	: D3447 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	:	Material	:
Written By	:	Due Date	: 21/08/2008
Checked & Approved By	: <u>MF 08-08-20</u>	Qty:	6 Um: Each
Comment	: Est.A 05.08.26 New issue KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6R1250	6061-T6 Round Bar 1.250
-----	--------------	-------------------------



Comment: Qty.: 0.4633 f(s)/Unit Total : 2.7796 f(s)  
 6061-T6 Round Bar 1.250  
 Material: 6061-T6 Bar Ø1.00 (QQ-A-200/8 or QQ-A-225/8)(  
 M6061T6R1.250)  
 Identify for D3447-7  
 Batch: M106634

6.84' 6061 1.125

RF 08/08/20

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL

Turn as per Folio

& Dwg B67-43001 Dwg Rev: RF

RF 08/08/20

3.0	LATHE CONV.	CONVENTIONAL LATHE
-----	-------------	--------------------



Comment: CONVENTIONAL LATHE

Turn 3.750" dimension to Ø0.975

Mill as per Dwg D3447

Deburr

RF 08/08/20

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE



RF 08/08/20 (14)

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK



RF 08-08-21 (14)

Date: Wednesday, 20/08/2008 8:47:04 AM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 41522

Part Number: D34477

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*m2 / FL 08.08.21* **(x14)**

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

Mask square section

START TIME:

*6:45*

OVEN TEMPERATURE:

*320°*

FINISH TIME:

*7:15*

*FL 08/08/22*

**(14)**

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*08-08-22* **x10**

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*PAT E*

*JS 08/08/22*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/08/26*

Job Completion

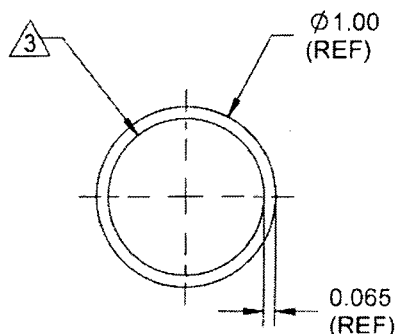
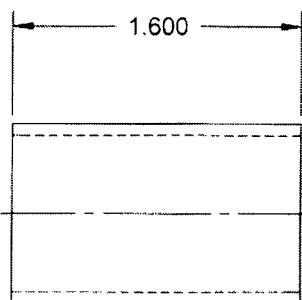


*08.08.26*



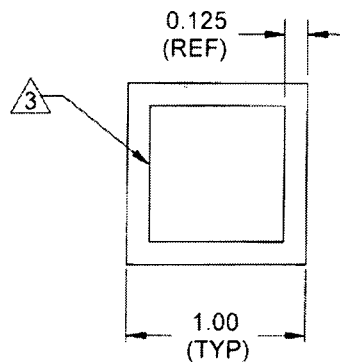
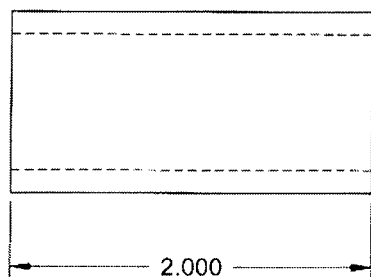
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3447</b>	REV. A SHEET 1 OF 4
DATE <b>05.07.19</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1
A	05.07.19	NEW ISSUE	

*[Handwritten signature]*  
05/07/19



#### **D3447-1 ROUND SPACER**

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING PER WW-T-700/6 OR  
AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8  
(REF. DART SPEC. M6061T6T1.000W.065)



*Wb 41522*

#### **D3447-3 SQUARE SPACER**

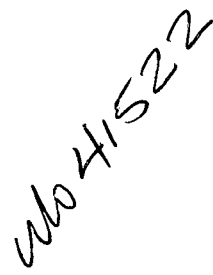
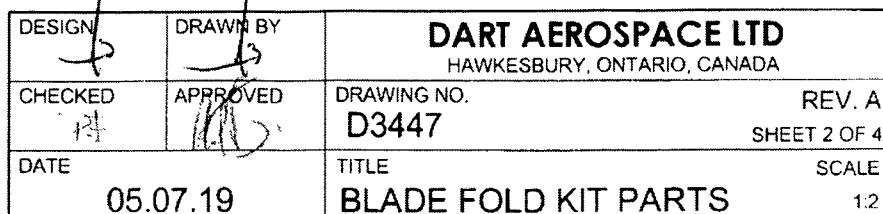
- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING  
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115/ 4116) OR  
PER AMS-QQ-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6TS1.000W.125)

#### **NOTES:**

- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK INSIDE OF TUBING BEFORE PAINTING.
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

**COPYRIGHT © 2005 BY DART AEROSPACE LTD.**

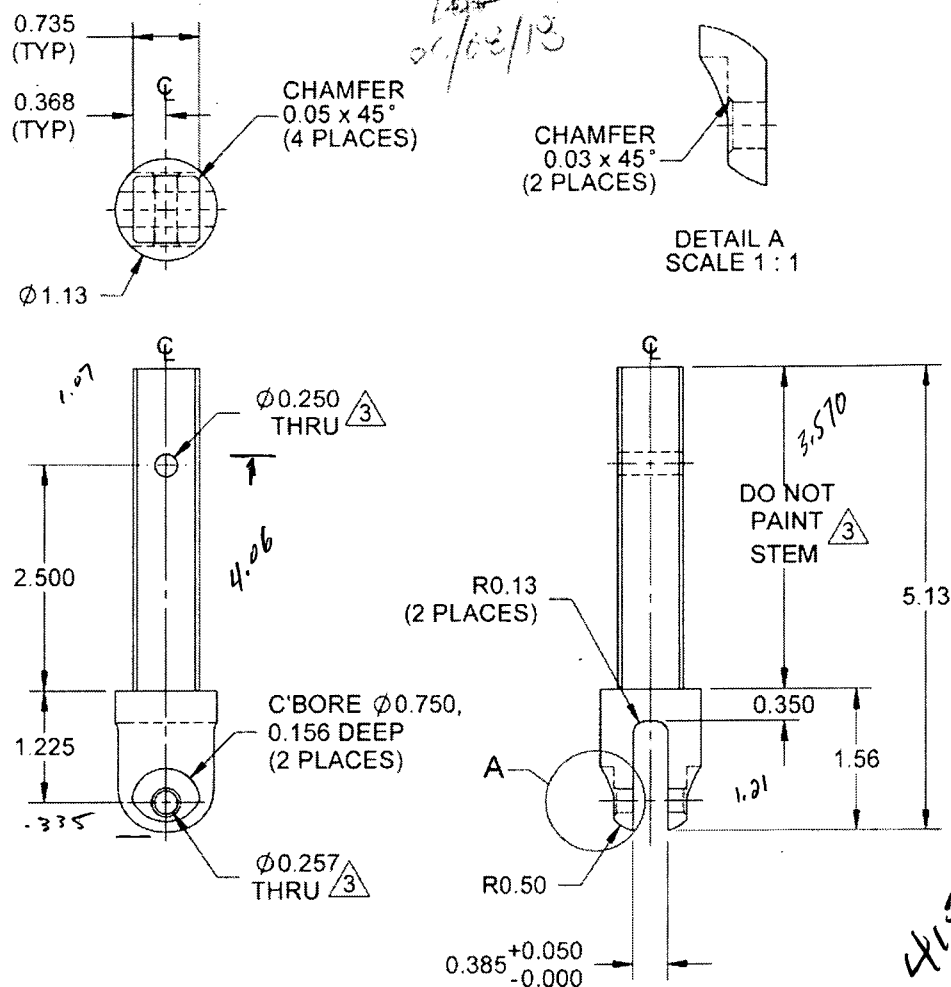
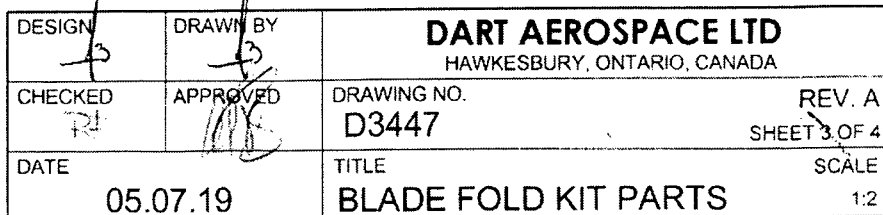
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



**SUPERSEDES PREMIER P/N B67-43001-99**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6R1.000)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



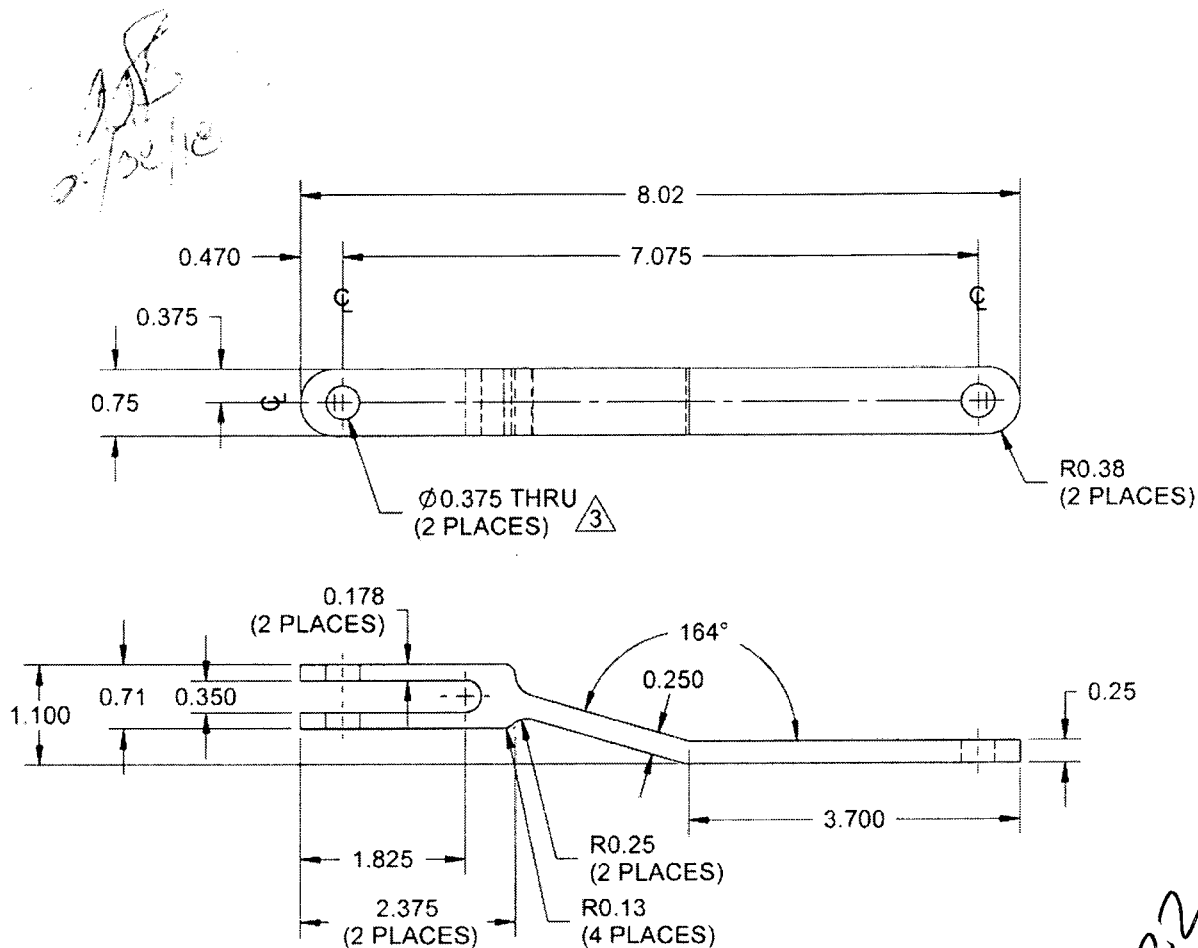
**SUPERCEDES PREMIER P/N B67-43001-145/-345**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6R1.125)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3447</b>	REV. A SHEET 4 OF 4
DATE <b>05.07.19</b>	TITLE <b>BLADE FOLD KIT PARTS</b>		SCALE 1:2



**D3447-9 SWING ARM**  
**SUPERSEDES PREMIER P/N B67-43001-263**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) COVER INSIDE HOLES PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

**COPYRIGHT © 2005 BY DART AEROSPACE LTD.**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD		Work Order: 41522
Description: <i>Clavis</i>		Part Number: D3447-7
Inspection Dwg:	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☒

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.735	+/- .010	.736				
.368	+/- .010	.368				
.05 x 45	+/- .030	.05 x 45°				
1.13	+/- .030	1.12				
.03 x 45	+/- .030	.03 x 45°				
1.250	+ .005 - .001	1.2495				
2.500	+/- .010	2.500				
1.225	+/- .010	1.225				
.750		.755				
.156	+/- .010	.155				
.257	+ .006 - .001	.262				
R.13	+/- .030	R.13				
S.13	+/- .030	S.13				
.350	+/- .010	.350				
1.56	+/- .030	1.55				
R.50	+/- .030	R.53				
.385	+ .050 - 0.0	.405				

Measured by: <i>RC</i>
Date: 08/08/20

Audited by: <i>[Signature]</i>
Date: 08.08.21

Prototype Approval: <i>N/A</i>
Date: <i>N/A</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	